

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011532**Date Inspected:** 10-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Chuan Qing, Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10 TOWER STRUT

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ED1-A6003-6-7, 8, 9, 10, 11, 12 A/B GREEN TAG NO. 11700

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

NORTH TOWER LIFT 4 B/C CORNER SEAM REPAIR

SMAW welding of weld joint 5A/B (Repair) located on NSTL4-3B/L.

Welder is identified as 052930. ZPMC CWI is identified as Mr. Wang Chuan Qing.

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The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR.

NORTH TOWER LIFT 4 A/E CORNER SEAM REPAIR

FCAW welding of weld joint 3A/B (Repair) located on NSTL4-3B/L.

Welder is identified as 066733. ZPMC CWI is identified as Mr. Wang Chuan Qing.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

BAY 11

EAST TOWER LIFT 5 C/D CORNER SEAM

SMAW welding of weld joint 16B located on ESD1-TL5-2B/F.

Welder is identified as 040724. ZPMC QC is identified as Mr. Xu Jun Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U4b-1.

WEST TOWER LIFT 4 D/E CORNER SEAM REPAIR

SMAW welding of weld joint 61A/B (Repair) located on WSTL4-2B/L.

Welder is identified as 202323. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
